

Work Order ID 56624

Tuesday, March 02, 2010 4:20:40 PM



Page 1

Item ID: D3389-1

Accept



Setup Start



Revision ID:

Item Name: Web

Stop



Start Date: 3/3/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 3/17/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: mf

Date: 10-3-2

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3389

Rev D

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut to length as per Dwg D3389 2-Drill pilot holes using DT8785 as per Dwg D3389 3-Open holes to finish size as per Dwg D3389 4-Deburr

DP

10-3-3

(4)

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Scolorbu

(4)

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4

11/2/3/4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 4/6

0.00

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/03/05
MF 10-3-4

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 56624

Parent Item: D3389-1

Parent Item Name: Web

Comments: IPP Rev:A 05.08.31 New issue KJ/JLM
 IPP Rev:B 06-02-08 As per Rev C JLM
 IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Start Date: 3/3/2010

Required Date: 3/17/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ D2500-3-100	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 100	Unit of Each	Qty on 179.0000	Remaining 4.0000	Qty	Date	Status
Ext'n -I' Beam Web 4"												

Warehouse

Location

Main Warehouse

ST

40196

51957

Loc Qty

179

16

163

Loc Code

[Handwritten signature]

10-3-3

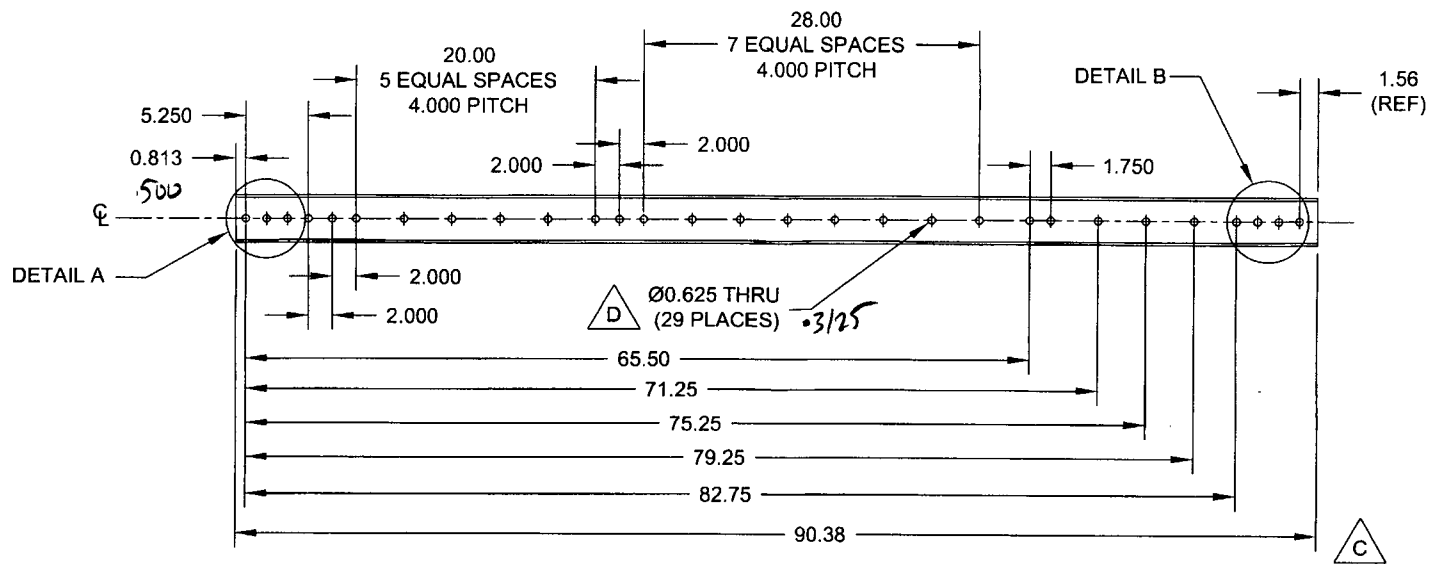
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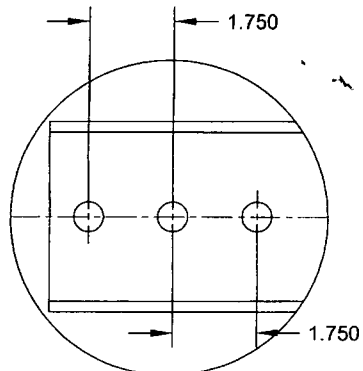
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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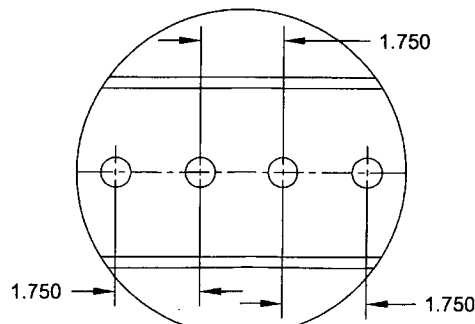
NOTE: Date & initial all entries



D3389-1 412 WEB



DETAIL A
SCALE 2:5



DETAIL B
SCALE 2:5

#56624

- NOTES:**
- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06

D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.09		

DART AEROSPACE USA, INC PORT HADLOCK, WA			
DRAWING NO.	D3389	REV. D	
TITLE	412 WEB	SCALE	1:10
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